

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012072**Date Inspected:** 08-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Yu Dong Ping, Du Zhi Qun	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10 TOWER STRUT

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ED1-A6001-1-7, 8, 9, 10, 11, 12 A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10**SOUTH TOWER LIFT 4 FIT LUG ON SKIN A**

FCAW welding of weld joint 35 located on SSTL4-1F/L.

Welder is identified as 066477. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

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FCAW welding of weld joint 44 located on SSTL4-1C/L.

Welder is identified as 066236. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-4333-Tc-P4-F.

SOUTH TOWER LIFT 4, A/E CORNER BACKFILL PLATE

This QA inspector witnessed Ultrasonic Testing (UT) performed by ZPMC NDT personnel on the weld joints of A/E corner backfill plate of South Tower lift 4 at 127M and 131M diaphragm. The components are identified as Tower components. The weld designations are as follows. Attached photographs provide additional detail.

SSTL4-1G/L-29, 98

SSTL4-1H/L-30

NORTH TOWER LIFT 4, C/D CORNER AND B/C CORNER

This QA inspector witnessed Magnetic Particle Testing (MT) performed by ZPMC NDT personnel on the excavated area of the repair locations of B/C corner seam and C/D corner seam of North Tower lift 2 at various locations. The components are identified as Tower components. The weld designations are as follows. Attached photographs provide additional detail.

NSTL4-3B/L-1A/B (C/D CORNER SEAM)

NSTL4-3B/L-5A/B (B/C CORNER SEAM)

BAY 11

TOWER STRUT ANGLE CONNECTION PLATE

SAW welding of weld joint 1B located on ND1-SA4-68-123M-5.

Welder is identified as 042195. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

SAW welding of weld joint 1B located on ND1-SA4-68-123M-8.

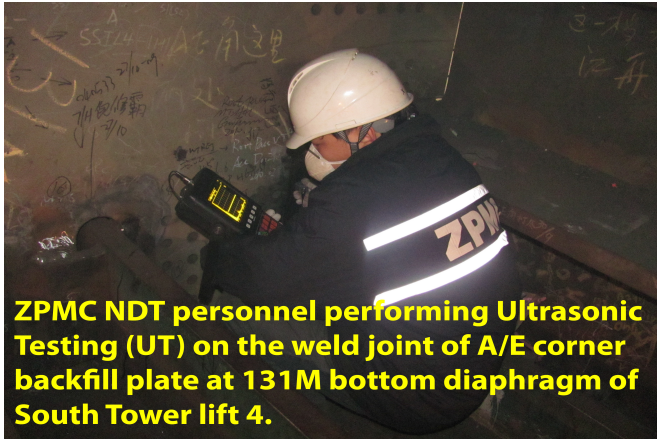
Welder is identified as 042195. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-Tc-U5-S-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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ZPMC NDT personnel performing Ultrasonic Testing (UT) on the weld joint of A/E corner backfill plate at 131M bottom diaphragm of South Tower lift 4.



ZPMC NDT personnel performing MT on the excavated area of C/D corner seam of North Tower lift 4.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer